

Work Order ID 133635

133635

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June-12-15 1:09:08 PM

Item ID: MISC - Testing Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eng Testing
 Start Date: 6/12/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00

100

Crosstubes

Crosstubes

Memo

0.00

1. Pick D6021 **M127271**
2. Machine to 2.3" OD x 6" Long
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.

1 φ φ **DAS**
12 15/5/20
9-89

110

0.00

110

Eng

Engineering

Memo

0.00

Eng Approval

1 φ φ **DAS**
12 15/5/20
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120		0.00							
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120

SprayPaint

Spray Painting

Memo

6. Apply Petit Paint Metal Primer 6455 per manufacturer's instructions. **M132244**
7. Prime and paint outside of tube per Dart QSI 005 4.2 **130992**
132422

DAS
12 15/5/20
9-89

130		0.00							
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130

Eng

Engineering

Memo

Eng Approval

DAS
12 15/5/20
9-89

140	QC21- Final Inspection - Work Order Release	0.00							
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140

QC

Quality Control

Memo

FOR TESTING
ONLY 15/6/30

SH 20150917